

25. The silver alloy composition of claim 24 wherein said silver is present in an amount at least 92.5% by weight.
26. The silver alloy composition of claim 24 wherein said copper is present in an amount of from about 2.0 to about 4.0% by weight.
27. The silver alloy composition of claim 24 that includes zinc in an amount of from about 2.0 to about 4.0% by weight.
28. The silver alloy composition of claim 24 wherein said germanium is present in an amount of from about 0.04 to no more than 2.0% by weight.
29. The silver alloy composition of claim 24 that includes an additive selected from the group consisting of indium, boron and a mixture of indium and boron in an amount of up to about 3.5% by weight.
30. The silver alloy composition of claim 29 wherein said mixture comprises up to about 2% by weight boron and up to about 1.5% by weight indium.
31. The silver alloy composition of claim 24 that includes tin amount up to about 6% by weight.
32. The silver alloy composition of claim 31 wherein said tin is present in an amount of from about 0.25 to about 6% by weight.
33. The silver composition of claim 24 wherein an increase in the amount of germanium does not result in linear hardening performance and that hardening is linear with the degree of work.
34. A fire scale resistant, work hardenable jewelry silver alloy composition comprising:
81-95.409% by weight silver;
0.5 -6% by weight copper;
0.05-5% by weight zinc;
0.02-2% by weight silicon;
0.01-2% by weight boron;
0.01-1.5% by weight indium; and,
0.01-no more than 2.0% by weight germanium.
35. A fire scale resistant, work hardenable jewelry silver alloy composition comprising:
75-99.159% by weight silver;

0.5-6% by weight copper;
0.05-5% by weight zinc;
0.02-2% by weight silicon;
0.01-2% by weight boron;
0.01-1.5% by weight indium;
0.25-6% by weight tin; and,
0.01-no more than 2% by weight germanium.

36. A fire scale resistant, work hardenable jewelry silver alloy composition comprising:

92.7% by weight silver;
4.577% by weight copper;
2.25% by weight zinc;
0.8% by weight tin;
0.07% by weight indium;
0.2% by weight silicon;
0.03% by weight boron; and
0.12% by weight germanium.

37. A fire scale resistant, work hardenable jewelry silver alloy composition comprising:

92.5% by weight silver;
5.75% by weight copper;
1.3% by weight zinc;
2.0% by weight silicon, and,
0.12% by weight germanium.

38. A fire scale resistant, work hardenable jewelry silver alloy composition comprising:

92.5% by weight silver;
5.75% by weight copper;
1.3% by weight zinc;
0.15% by weight tin;
0.2% by weight silicon; and,
0.1% by weight germanium.

39. A fire scale resistant, work hardenable jewelry silver alloy composition comprising:
92.7% by weight silver;
4.825% by weight copper;
1.95% by weight zinc;
0.15% by weight silicon; and
3.75% by weight germanium.
40. A fire scale resistant, work hardenable jewelry silver alloy composition comprising:
92.5% by weight silver;
7.2% by weight copper;
0.1% by weight tin;
0.1% by weight silicon; and
0.1% by weight germanium.
41. A fire scale resistant, work hardenable jewelry silver alloy composition comprising:
92.5% by weight silver;
3.365% by weight copper;
3.365% by weight zinc;
0.2% by weight indium;
0.05% by weight silicon;
0.02% by weight boron; and,
0.5% by weight germanium.
42. A fire scale resistant, work hardenable jewelry silver alloy composition comprising:
92.7% by weight silver;
3.8% by weight copper;
2.6% by weight zinc;
0.2% by weight silicon;
0.2% by weight boron, and,
0.5% by weight germanium.
43. A fire scale resistant, work hardenable jewelry silver alloy composition comprising:
92.7% by weight silver;

3.78% by weight copper;
2.6% by weight zinc;
0.42% by weight silicon; and,
0.5% by weight germanium.

44. A fire scale resistant, work hardenable jewelry silver alloy composition comprising:

92.5% by weight silver;
5.8% by weight copper;
0.2% by weight tin;
0.17% by weight silicon;
0.03% by weight boron, and,
0.3% by weight germanium.

45. A fire scale resistant work hardenable jewelry silver alloy composition comprising:

92.5% by weight silver;
4.83% by weight copper,
2.25% by weight zinc;
0.1% by weight indium;
0.2% by weight silicon; and
0.12% by weight germanium.

46. A fire scale resistant, work hardenable jewelry silver alloy composition comprising:

92.7% by weight silver;
4.0% by weight copper;
2.6% by weight zinc;
0.2% by weight silicon; and
0.5% by weight germanium.

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